



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

**RBW6522A00231-W142AJ-
3T-9**

Job Sheet 199144



DAS
21
9-89

Part No: RBW6522A00231-W142AJ-3T-9 Job Qty: 1 pcs **6**

Part Name: Large Knob



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/7/19

Description:

Type: SOLD

Note: DWG RBW6522A00231-W142AJ-3T Rev 5 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-2500Y - 1	1 pcs	10/7/19	10/7/19	1.00	0.25	SL-2500Y - 1		SL 19-9-9
120	QC 2	1 pcs	10/7/19	10/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		SL 19-9-9
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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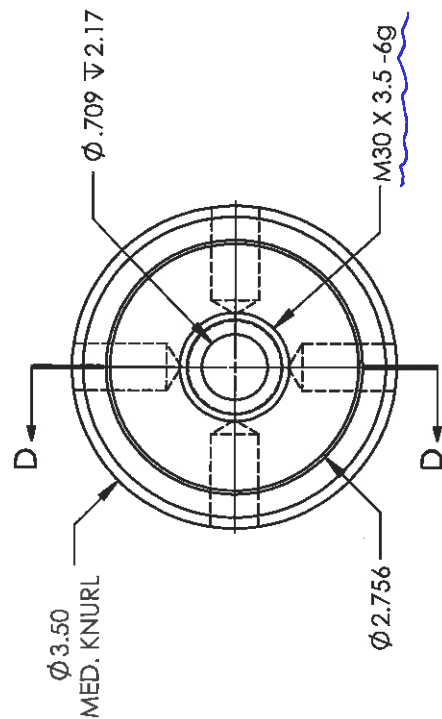
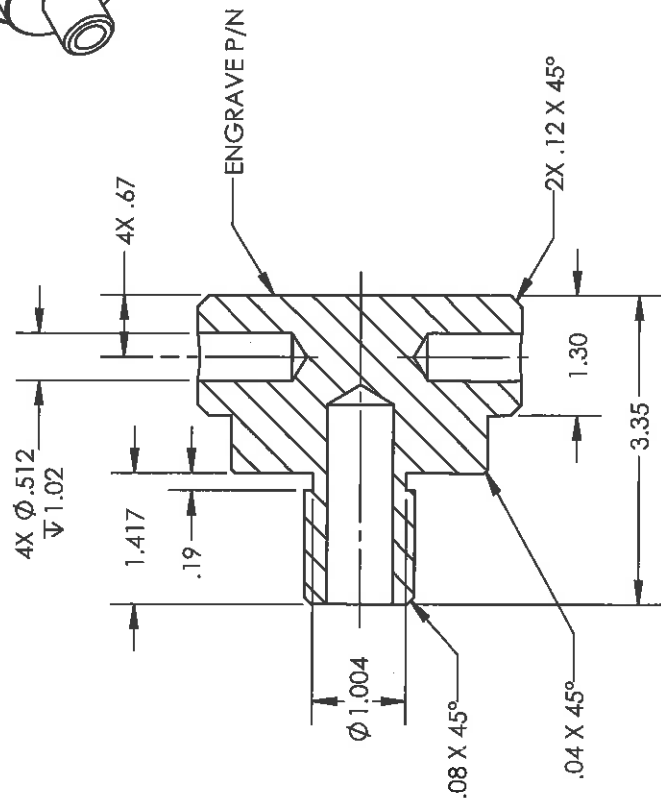
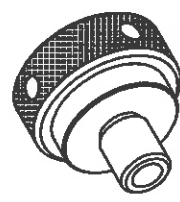
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	1 pcs	10/7/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	81
				QC 6 - 40	9-89
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	1 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	1 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 110 - (Mori SL2500Y Lathe) 1-Machine as per DWG. FB <u>C910</u> FOLIO REV: <u>AA</u> DWG REV: Descriptions: <u>5</u> 2-Deburr 120 - (QC2- Inspect parts off machine FAI/FAIB) Engrave T/N and/or P/N number using Marktronic engraver as per DWG. 130 - (QC8- Inspect parts - second check) 150 - (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO <u>44487</u> -Black oxide finish, MIL-C- 13924C Class 1 -Certificate of Conformity is required 160 - (Receive & Inspect for Damage & Mat'l Certs) 170 - (QC6- All purchased or subcontracted products) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R3.750	AISI 4140 Q&T Round Bar	.2800 ft (.28 ea)	110-SL-2500Y - 1	SO46344
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-2500Y - 1	MT-4140QT-R3.750	0	6	0
Part Specifications				
Specifications could not be found.				

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
3	15-0336	-9 CH'D DIMS WAS Ø3.543 IS Ø3.50, WAS 1.299 IS 1.30, WAS 4X .669 IS 4X .67, WAS 3.346 IS 3.35, ADDED NOTE ENGRAVE P/N.	10/14/2015
4	16-0250	-9 ADDED HEAT TREAT; ADDED FINISH SPEC.	12/5/2016
5	17-0044	-9 CH'D THREAD CALL OUT WAS 30 X 3.5 IS M30 X 3.5 -6g.	4/14/2017



TITLE		TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO.		RBW6522A00231-W142AJ-3T-9	
REV		5	
MATERIAL		4140/4142	
HEAT TREAT		RC 28-34	
FINISH		BLACK OXIDE	
SPEC		QMSH-6.2.2 B.O. REV D	
DRAWN BY		PERRITT	
CHECKED		CLOUGH	
OPPS APPR		ANDERSON	
QA APPR		LINDSAY	
APPROVED		GILBERT	
SCALE		1:2	
DATE		10/5/2010	
SHEET		8 OF 10	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1903144 M/S
19-08-13

(-9)

LARGE KNOB

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____	DISPOSITION	Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS	Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																								
Date: _____	Sequence #: _____	QTY Affected: _____																																																																										
Description Work Order Deviation		Disposition																																																																										
Root Cause <table style="width: 100%;"> <tr> <td>Operator</td><td>☐</td> </tr> <tr> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> </tr> <tr> <td>Handling/Preservation</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> </tr> <tr> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Human Factors</td><td>☐</td> </tr> </table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table style="width: 100%;"> <tr> <td>Pressure/Forced</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Bending</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Tolerance</td><td>☐</td> </tr> <tr> <td>Crushing</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain Direction</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td> <td>Incomplete/Unclear Instructions</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Mislabeled</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Off-set/Set-up</td><td>☐</td> <td></td><td></td> </tr> </table> Other/Details: _____			Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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		Completed By																																																																										
		Lead hand / Supervisor																																																																										
		QC / QA Coordinator																																																																										



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044487**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044487

PO Date: 9/12/19

Due Date: 9/20/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199144	RBW6522A00231-W142AJ-3T-9	Large Knob (Outside Processing) - Black Oxide - Issue P/O to Groupe Altech; PO _____ - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required	Firmed	-	9/20/19	6 pcs	0 pcs	6 pcs	\$5.71428/pcs	\$34.29
2	199334	RBW6521A00138-W142AH-3T-11	Wrench - Issue P/O; _____ - Black oxide finish, MIL-C-13924C Class 1 - Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. - Material type; 4140 - Certificate of Conformity is required	Firmed	-	9/20/19	4 pcs	0 pcs	4 pcs	\$5.71428/pcs	\$22.86

SEP 20 2019



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PURCHASE ORDER

POHB044487



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	198489	RBD29823-5A	Tail Rotor Nut Wrench "D" Model (New Design) -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed -	-	9/20/19	6 pcs	0 pcs	6 pcs	\$5.71428/pcs	\$34.29
4	196077	RBW5605G00351-3G-1	Shoe -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -	-	9/20/19	5 pcs	0 pcs	5 pcs	\$5.71428/pcs	\$28.57
Grand Total:											\$120.00



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PURCHASE ORDER

POHB044487



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/13/19 3:48 PM Dart.Guerin.Kimberley


Certificat de Conformité / Certificate of Compliance


0 2 2 3 8 5 - 2

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip
022385 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
23-Sep-2019		Ross Montieth				POHB044487				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir / Back Order
1	RBW6522A00231-W142AJ-3T-9 Rev.	RBW6522A00231-W142AJ-3T-9 OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1		OXIDE-BLACK CH	6	6	0		0	0

RECEIVED

SEP 23 2019

DART AEROSPACE LTD.

DAS
81
9-89

 DAS
 81
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 SEP 23 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

 Epaisseur réelle
 Actual Thickness

 Inspecteur Qualité
 Quality Inspector

 Réçu par
 Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.